

Date: Friday, 9/14/2007 2:01:59 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CROSSTUBE EXTRUSION (407 AFT)
Job Number : 34689	
Estimate Number : 11978	
P.O. Number : <i>N/A</i>	Part Number : D6011115
This Issue : 9/14/2007 S.O. No. : <i>N/A</i>	Drawing Number : D6011 REV A I <i>RE</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : A I <i>RE</i>
Previous Run : 32307	Material : <i>N/A</i>
Written By : _____	Due Date : 1/30/2008 Qty: 10 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A 01.08.17 New Issue SM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *4611**CL 7/09/18**(10)*

a) Order as per Dwg D6011

b) Material: 2.750 x 0.650 wall 7075-T6/T6511 (WW-T-7007 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube

c) Minimum ultimate tensile strength = 77 ksi

d) Minimum tensile yield strength = 66 ksi

e) Tolerance are per ASTM B210 (see details on Dwg D6011)

f) Material certification required

2.0	D6011115P	Crosstube Material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Crosstube Material

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

*RE**8/01/03**(11)*

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg

08/01/04 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/01/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CROSSTUBE EXTRUSION (407 AFT)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten signature and initials

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: MAT 27

J.F. 08/01/04

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(u)

Comment: FINAL INSPECTION/W/O RELEASE

08/01/07

Job Completion



min 2008/1/4
W

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

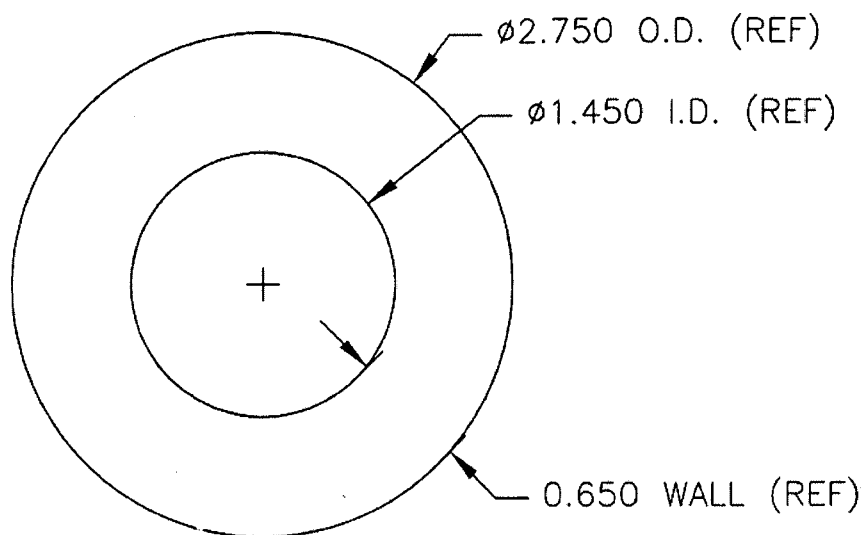
NOTE: Date & initial all entries



DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D6011	REV. A SHEET 1 OF 1
DATE 01.08.16		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	01.08.16	NEW ISSUE	
A1	02-01-29	UPDATE TOLERANCE ON OD.	

SPECIFICATION CONTROL DRAWING

RELEASED
01.08.17



NOTES

- 1) D6011-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 115" LONG TUBE: D6011-115

- 2) MATERIAL: 2.750 OD x 0.650 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi

- 3) TOLERANCES ARE PER ~~ASTM B210~~ AS FOLLOWS: ~~ANSI H35.2~~ AS FOLLOWS
O.D.: ~~± 0.006 MEAN (± 0.012 INCLUDING OVALITY)~~ ± 0.015 MEAN (± 0.030 INCL. OVALITY)
WALL: ± 0.020 MEAN (± 0.065 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.125/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH

- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34689

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by Road, Redditch, Worcestershire B98 7HN, England
phone (01527) 484500, Facsimile (01527) 484501

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No. C/151440/1

Customer EROSPACE LIMITED ERDEEN STREET SDBURY OXON ENGLAND	Your Order No PO00004611	Other Tests Passed
	Your Part No D6011-115P	
Our Order No 94945/8		
Packing Note No 151440	Date 30/11/07	
Packages 1 CASE	Specification 7075 TC QQ-A-200/11E	
Description ESS EXT TUBE 2.750 INS O/D .650 INS W/T 7075 Alloy 115.08 inches		

15.00 inches		Tensile Test				Chemical Analysis %															H cc/ 100 gm
Nett Weight Lbs		Test No	0.2% Proof Stress KSI	Tensile Strength KSI	% Elongation 4 x Dia	Heat or Cast No	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Zr			Ti			
549		331217 LO	73.0	85.6	7		2N267	.09	.26	1.53	.04	2.58	.19	.01	5.85	.01			.03	.16	

CASE NO.12978

ALLOY MELTED IN THE UNITED KINGDOM

Inspected Inspection Representative

Terry Layton For and on behalf of BA Tubes

Head Office: The Victoria, 150-182 Harbour City
Quays, Salford, M50 3BP, England.
Registration No. GB 668 2142 26



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